

ENGINEERING CHANGE NOTICE
DART AEROSPACE LTD

Date: 19.03.07	Job No.: RB18-BELL	ADR Yes/No: N	ADR Date: <i>mpp</i>
Product No.: DART TOOLING BELL	Created By: VM	Approved By: <i>WJ</i>	ECN #: 19- 572
Product Name: JET RANGER FIELD KIT	Checked By: <i>WJ</i>		

Reason for Change:
ITEMS MISSING

Documents Released:

RBT18510 REV L

IF APPLICABLE: NCR: _____ PAR: _____ CAR: _____ CIR: _____ URF: 19-572

PAPERWORK UPDATE ☐

PARTS MUST COMPLY ☒

PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance / Customer Support Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Airbus	N			
3	Notify Leonardo	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	N			
7	Update Document Record (DR)	N			
8	Update Product Compatibility Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10		N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	MD		<i>Comp 19.03.07</i>
12	Update Product Specification Files (Bluefiles)	N			
13	Update Approved/Preliminary Dwg PDF Files	Y	MD		<i>Comp 19.03.07</i>
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	MD		<i>Comp 19.03.07</i>
17	Update / Verify Authorized Release Certificate Database	Y	MD		<i>Comp 19.03.07</i>
18	Create / Update Change Record Form / Item Card Database	N-Y	MD		
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	N			
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	N			
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

Description / Action:

CLOSE URF 19-572

STOCK NEED TO BE RE-WORK PER REV L (see drawing for more info)

RELEASE RBT18510 REV L DRAWING

PLACE DRAWING RBT18510 REV 10 IN SUPERCEED FOLDER

35K ARTN

5028081
5123722

5123723

-2
-3
-5
-6

APP-14132007
see attached
W 20.03.03

191872

ECN Verified & Complete: _____

Date: _____



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ORDER ACKNOWLEDGEMENT

CUSTOMER

Customer Code: CHPAN01

Sold To: Helicopteres Panorama Ltee
360 Chemin De L'Aeroport
Alma QC G8B 5V2
Canada
Phone: 418 668 0761

Ship To: Happy Gas INC
#102-11010 Airport Drive, Hangar 1
Grand Prairie AB T8V 7Z5
Canada

ORDER

Order No : 13503

Date: 2/8/19

Ship-To Contact: Normand Cote

Email: ncote@panoramahelico.com

Cust PO No: 3751

FOB: Shipping Point

Ship Via:

Freight Terms: PrePaid

Terms: Net 30

INCO Terms: Ex Works

Order Taker: Caitlin Crooks

Order Taker Phone:

Order Taker Email: ccrooks@dartaero.com

Line No	Due Date	Ship Date	Part	Description/Note	Quantity	Unit	Price	Unit	Extended Price
1	2/22/19	2/22/19	D205-634-011	Skidtube with Standard Wearplates Fits LH or RH	1	pcs	\$6,210.00USD	pcs	\$6,210.00 USD
				12% Discount Diamond			-12.00		\$-745.20
Sub Total									\$5,464.80
Tax									\$710.42
Sub Total									\$6,175.22 USD
Grand Total									\$6,175.22 USD

ORDER NOTES

Day And Ross ACCT#148127

Remit to: DART Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario K6A 1K7 Canada

Tel: 613 632 5200

Fax: 613 632 5246

accounting@dartaero.com

GST/HST 10127 2607

Note: A minimum 15% restocking fee is applicable. Custom items are non-refundable. Full warranty details are available at www.dartaerospace.com

International / US Wires:

Swift Code: CHASUS33 Bank Routing #: 021000021 Account #: 133281000

Bank Name: JPMorgan Chase Bank 201 St. Charles Ave., New Orleans, LA USA 70170

Account Name: DART Aerospace Ltd.

Notification October 2018: Our banking information has remained unchanged

RBT18510 x 2 mm
others?
sold?

Rework ship
2528

Part status
does not allow
job creation
19-02-26

Under Review Notification

Raised By: Ketan Tailor

Product #: Dart Tooling Bell

Date: February 12, 2019

Product Name: Jet Ranger Field Kit

[illegible]**Description of Issue:**

Need to add foam inside of pelican case to protect tools on top. Use item -81 from REV. 8A (as per deviation)

3 in QRTN
5028001
S123722

Distribution:

VP Operations

Director of Operations

Director Quality Assurance

QC Coordinator

Director of Engineering

Chief Engineer

Engineering Project Managers

Engineering Clerk

Customer Support Manager

Production Engineers

Production Planners

Purchasing Manager

Technical Support

Product Manager - Solutions Provider

Supply Chain Director / Senior Buyer

Marketing Eugene

H:\Forms\Engineering\Approved ENG Online\URF revF.xls

Manager Market

123723



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ORDER ACKNOWLEDGEMENT

CUSTOMER

Customer Code: CBGHE01

Sold To: BGHelicopters

Heliport Circuit de Barcelona
08160 Montmeló
Catalunya
Spain
Phone: +34 935 167 044

Ship To: BGHelicopters

Heliport Circuit de Barcelona
08160 Montmeló
Catalunya
Spain
Phone: +34 935 167 044

ORDER

Order No : 13240

Date: 2/1/19

Ship-To Contact: David Iturbide

Email: david@bg helicopters.com

Cust PO No: 001-19BGH

FOB: Shipping Point

Ship Via: See comments below

Freight Terms: Third Party Billing

Terms: Prepay

INCO Terms: Ex Works

Order Taker: Kinga Lysiak

Order Taker Phone:

Order Taker Email: klysiak@dartaero.com

Line No	Due Date	Ship Date	Part	Description/Note	Quantity	Unit	Price	Unit	Extended Price
1	3/7/19	3/7/19	RBT18510p	Bell 206A/B Field Maintenance	1	pcs	\$9,955.00USD	pcs	\$9,955.00 USD
				Special Discount			-10.00		\$-995.50
Sub Total									\$8,959.50 USD
Grand Total									\$8,959.50 USD

ORDER NOTES

RA570 applies to this order

FEDEX account N° 995998556, and please choose economy

Custom Clearance To Be Billed To Receiver

Duties & Taxes To Be Billed To Receiver

Ship Order As Soon As Possible

Use Discounted Price On Shipping Documents

10061129

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. <u>RBT18510 Rev. 10</u>		DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>		DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Cross tube <input type="checkbox"/> Eng. (Non-AW) <input type="checkbox"/> Engineering <input type="checkbox"/> Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Water Jet <input type="checkbox"/> Large Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier Quality <input type="checkbox"/>																													
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS)042 Feb 5, 2019																											
Description Work Order Deviation				Disposition		Completed By																											
Kuri-Tech Hose (K010-0608) easily pulls out of Coupling (McMaster Carr 51495K116) *sub component of kit* ADD ITEM -81 (FOAM LID) FROM REV. 8A Hot glue the foam lid into the pelican case to protect the tools in the top foam. Foam lid must be made per RBT18510-81 REV. 8A. STEP file. Foam lid to be made with Black Ethafoam 220 or EQUIV.				Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one end of the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable). This deviation is acceptable. The fit, form and function of the part will be as originally intended.		Lead hand / Supervisor QC / QA Coordinator																											
Root Cause Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Presservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input checked="" type="checkbox"/> X Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/>		FAULT CATEGORY <table border="0"> <tr> <td><input type="checkbox"/> Pressure/Forced</td> <td><input type="checkbox"/> Contamination</td> <td><input type="checkbox"/> Power Loss/Surge</td> <td><input type="checkbox"/> Positioned Wrong</td> </tr> <tr> <td><input type="checkbox"/> Bending</td> <td><input type="checkbox"/> Misaligned/off center</td> <td><input type="checkbox"/> Folio/Program</td> <td><input type="checkbox"/> Outside Tolerance</td> </tr> <tr> <td><input type="checkbox"/> Crushing</td> <td><input type="checkbox"/> BOM/Route</td> <td><input type="checkbox"/> Grain Direction</td> <td><input type="checkbox"/> Drawing</td> </tr> <tr> <td><input type="checkbox"/> Cracks</td> <td><input type="checkbox"/> Broken/Damage/Defect</td> <td><input type="checkbox"/> Weld</td> <td><input type="checkbox"/> Finish</td> </tr> <tr> <td><input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist</td> <td><input type="checkbox"/> Incomplete/Unclear Instructions</td> <td><input type="checkbox"/> Wrong Stock Pulled</td> <td><input type="checkbox"/> Part Lost/Missing</td> </tr> <tr> <td><input type="checkbox"/> Marks/Chatter</td> <td><input type="checkbox"/> Drill Holes</td> <td><input type="checkbox"/> Out of Sequence</td> <td><input type="checkbox"/> Misread</td> </tr> <tr> <td><input type="checkbox"/> Mislabeled</td> <td><input type="checkbox"/> Fit/Function</td> <td><input type="checkbox"/> Off-set/Set-up</td> <td></td> </tr> </table>				<input type="checkbox"/> Pressure/Forced	<input type="checkbox"/> Contamination	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Bending	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Tolerance	<input type="checkbox"/> Crushing	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain Direction	<input type="checkbox"/> Drawing	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Weld	<input type="checkbox"/> Finish	<input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist	<input type="checkbox"/> Incomplete/Unclear Instructions	<input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Misread	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Off-set/Set-up	
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Other/Details:																																	

Linda Lacelle

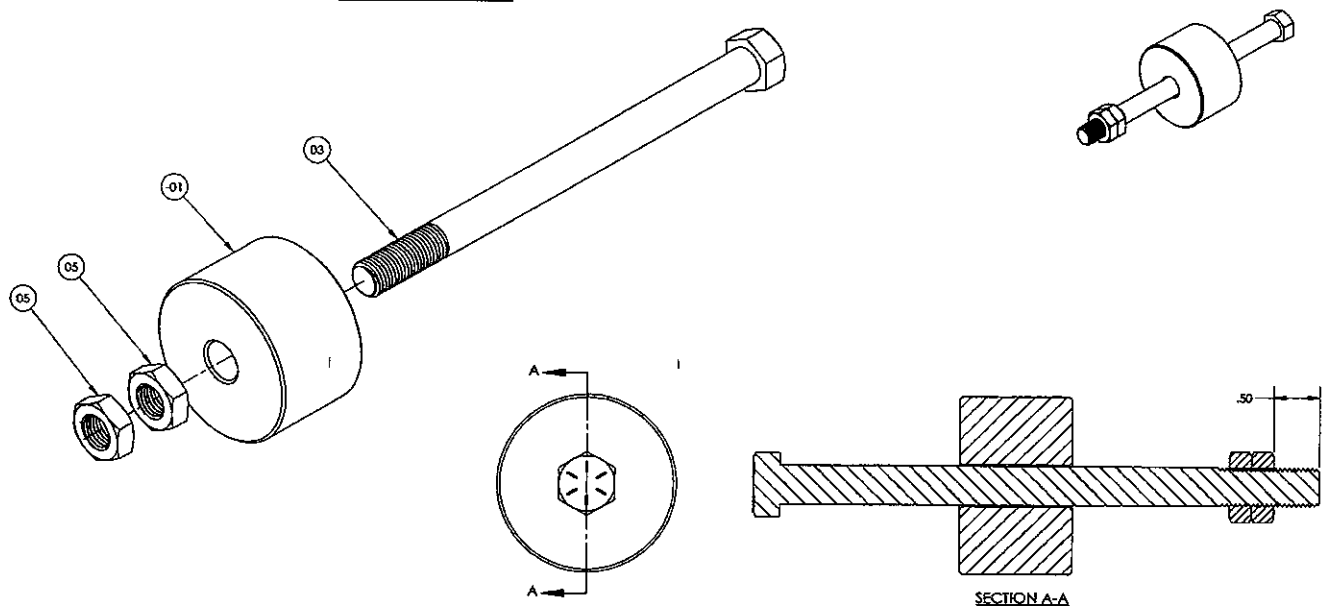
From: qpulse@dartaero.com
Sent: Friday, February 8, 2019 12:02 PM
To: Patrick Smith; Linda Lacelle
Subject: Action added to Non Conformance
Attachments: Locate Record.qpulse

Details: An action has been added to the following Non Conformance;

Number	NCR19-7061
Report	Non-Conformance Report
Process	Employee finding
Details	Raised by customer support - Kit Part# RBT18564: RBE2-10-1 sub part has been damaged by the rivets in the top portion of pelican case. Its is also corroded. Found issue when inspecting RA570
Owner	Lee, Mike
Target Date	
Type	Corrective Action
Number	3
Owner	Lacelle, Linda
Details	Re-work kits in quarantine- damaged part# RBE2-10-1 as soon as possible

Handwritten notes: "newson" and "RBT18564?" are written in blue ink over the first table. A blue circle is drawn around the word "is" in the "Details" row of the first table.

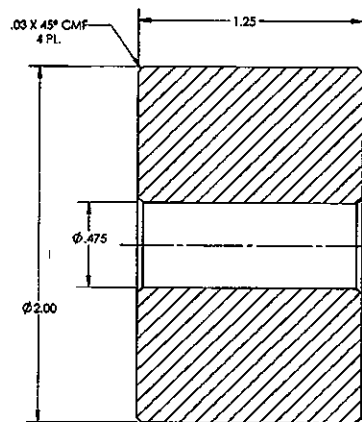
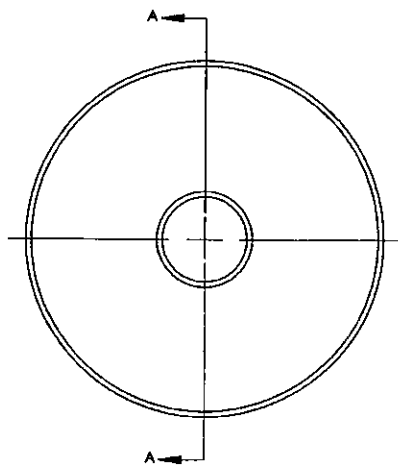
ITEM #	QTY	PART #	TITLE	PG	REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-01	1	RBE2-10-1-01	SLIDE	2	A	NEW ISSUE	17-000	17.10.02	VM	WM
03	1	McMaster#91237A481	HEX HEAD SCREW 7/16"-20 x 8" L.G.	-						
05	2	McMaster#93676A820	THIN HEX NUT 7/16"-20	-						



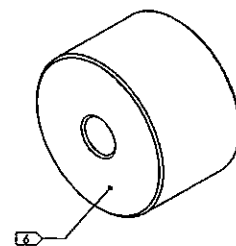
RBE2-10-1 FUEL SYSTEM CARTRIDGE REMOVAL TOOL

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A

DART AEROSPACE		Hemelock, Ontario, Canada	
TITLE: FUEL SYSTEM CARTRIDGE REMOVAL TOOL			
Part No: RBE2-10-1		REV: A	
DESIGN BY: VM 10/02/2017	DATE: 10/02/2017	SCALE: 1:1	FRACCTIONS: 1/16"
CHECKED BY: SAC 10/02/2017	DATE: 10/02/2017	1. DIMENSIONS ARE IN PARENTS UNLESS OTHERWISE SPECIFIED	
APPROVED BY: VM 10/02/2017	DATE: 10/02/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5-2009	
RECAL: NTS		WEIGHT: N/A	
SHEET 1 OF 2			
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SECTION A-A



RBE2-10-1-01 SLIDE

- NOTES:
- 1) MATERIAL: AISI 1018/1020 CR
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE
 - 4) SPEC: MIL-C-13824, CLASS 1; MIL-C-16173 GRADE 4
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: MACHINE ENGRAVE P/N & S/N

DART AMERICA'S		Hamlet, Ontario, Canada	
PART NAME: SLIDE			
PART NO: RBE2-10-1-01			
DESIGNED BY: USA 10/02/2017	300 X 3 361	FUNCTIONS & USE	REV: A
DESIGNED BY: USA 10/02/2017	3" ± .4"	ANALYSIS & TEST	
CHECKED BY: SAC 10/02/2017		UNLESS OTHERWISE SPECIFIED	
APPROVED BY: DP 10/04/2017		1. DIMENSIONS ARE IN INCHES	
APPROVED BY: DP 10/04/2017		2. INTERFERE AND TOL PER	
DATE: 10/02/2017		3. DIMENSIONAL LIMITS APPLY	
SCALE: NTS	WEIGHT: 1.558 LBS	QUANTITY: 1	SHEET 2 OF 2

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Linda Lacelle

From: Ketan Tailor
Sent: Tuesday, February 26, 2019 11:21 AM
To: Linda Lacelle; Vanessa Morel
Cc: Chantal Lavoie; Daniel Paquette; David Duval; Michael Lee; Mychel Beauregard; Patrick Duval; Praduman Khayargoli; Steven Drouin
Subject: RE: URF 19-572 (RBT18510)
Attachments: RBE2-10-1-RevA.pdf

Hey Linda,

RBE2-10-1 was damaged due to the missing top foam. So we will have to manufacture another one at Rev. A to replace it.

Thanks,
Ketan

From: Linda Lacelle <llacelle@dartaero.com>
Sent: February-25-19 2:41 PM
To: Vanessa Morel <vmorel@dartaero.com>
Cc: Ketan Tailor <ktailor@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>; Daniel Paquette <dpaquette@dartaero.com>; David Duval <dduval@dartaero.com>; Michael Lee <mlee1@dartaero.com>; Mychel Beauregard <mbeauregard@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Praduman Khayargoli <pkhayargoli@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>
Subject: RE: URF 19-572 (RBT18510)

Understood, but what about the RBE2-10-1's? svp?

From: Vanessa Morel <vmorel@dartaero.com>
Sent: Monday, February 25, 2019 2:36 PM
To: Linda Lacelle <llacelle@dartaero.com>
Cc: Ketan Tailor <ktailor@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>; Daniel Paquette <dpaquette@dartaero.com>; David Duval <dduval@dartaero.com>; Michael Lee <mlee1@dartaero.com>; Mychel Beauregard <mbeauregard@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Praduman Khayargoli <pkhayargoli@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>
Subject: Re: URF 19-572 (RBT18510)

Hi Linda,

You can proceed with the deviation for the current order. All stock need to be rework per deviation. A top foam need to be added. The drawing will be update soon.

If you have any questions let me know,

Vanessa

Envoyé de mon iPhone

Le 25 févr. 2019 à 14:10, Linda Lacelle <llacelle@dartaero.com> a écrit :

All,

I know there is a URF for this, and a deviation, but still have not seen any ECN ? Also, I am about to make the rework orders, but am unsure of what needs to be done, besides changing out the foam. I see from below the RBE2-10-1's need to be reworked...what needs to be done to them pls??

<image001.png>

From: Ketan Tailor <ktailor@dartaero.com>

Sent: Tuesday, February 12, 2019 10:52 AM

To: Chantal Lavoie <clavoie@dartaero.com>; Daniel Paquette <dpaguette@dartaero.com>; Dart Sales <DartSales@dartaero.com>; David Duval <dduval@dartaero.com>; Frederick Leblanc <fleblanc@dartaero.com>; Jean Francois Cadieux <jcadieux@dartaero.com>; Jean Francois Sauve <jfsauve@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>; John Chuprun <jchuprun@dartaero.com>; Ketan Tailor <ktailor@dartaero.com>; Konrad Sauve <ksauve@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Marie Lajeunesse <mlajeunesse@dartaero.com>; Michael Lee <mlee1@dartaero.com>; Michelle GagnonDonovan <mgagnondonovan@dartaero.com>; Mychel Beauregard <mbeauregard@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Praduman Khayargoli <pkhayargoli@dartaero.com>; Regis Quenneville <rquenneville@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Ross Black <rblack@dartaero.com>; Ryan Williamson <rwilliamson@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>; Steven Hemmerich <shemmerich@dartaero.com>; Support Eugene <support.or@dartaero.com>; Support Hawkesbury <support.on@dartaero.com>; Vanessa Morel <vmorel@dartaero.com>

Subject: URF 19-572 (RBT18510)

Hey Everyone,

Please find the attached URF.

Linda Lacelle

From: Michelle GagnonDonovan <mgagnondonovan@dartaero.com>
Sent: Thursday, March 7, 2019 2:38 PM
To: Daniel Paquette; David Duval; Eric Lalande; Jean Francois Sauve; Jean-Luc Menard; Jennifer Renwick; Jesse White; John Chuprun; Linda Lacelle; Lisa McMachen; Marc Bellavance; Marcel Daviau; Marie Lajeunesse; Patrick Duval; Robert Aboud; Ross Black; Sian Willems; Steven Drouin; Steven Hemmerich; Support Eugene; Support Hawkesbury
Subject: REVISED: ECN 19-572
Attachments: ECN19-572.pdf

Hello All,

Please find revision to ECN 19-572 attached. Part disposition has changed from "Parts must comply" to "Previous Parts Satisfactory". See Rework instructions in bottom block of form.

Thank you,

Michelle Gagnon-Donovan

Document Control

DART AEROSPACE

T 1 613 632-5300 > 251

www.dartaerospace.com



From: Michelle GagnonDonovan

Sent: Thursday, March 07, 2019 1:36 PM

To: Daniel Paquette <dpaquette@dartaero.com>; David Duval <dduval@dartaero.com>; Eric Lalande <elalande@dartaero.com>; Jean Francois Sauve <jfsauve@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>; Jennifer Renwick <jrenwick@dartaero.com>; Jesse White <jwhite@dartaero.com>; John Chuprun <jchuprun@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Lisa McMachen <lmcmachen@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Marie Lajeunesse <mlajeunesse@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Ross Black <rblack@dartaero.com>; Sian Willems <swillems@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>; Steven Hemmerich <shemmerich@dartaero.com>; Support Eugene <support.or@dartaero.com>; Support Hawkesbury <support.on@dartaero.com>

Subject: ECN 19-572

Hello,

Please find a copy of ECN 19-572 attached.

Thank you,

Michelle Gagnon-Donovan
Document Control

DART AEROSPACE
T 1 613 632-5300 > 251

www.dartaerospace.com

